

Work Order ID 59153

Thursday, May 27, 2010 9:21:58 AM



Page 1

Item ID: D3794-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 5/27/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-5-27* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

B10-6-4

(24)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-6-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subloc

Wank
(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>14</u>	0.00							
	Packaging								
Packaging	Memo	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

10-6-4 S/S40

10/06/07

mf
10-6-7

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 27, 2010 9:22:02 AM

Page 1

Work Order ID: 59153



Parent Item: D3794-3



Parent Item Name: Gasket

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	479.2531	1.2828	21.60505	30.8		
NEOPRENE SHEET 0.063													

Location

Loc Qty

Loc Code

MAT

374

114691

374

MAT052

105.2531

114176

105.2531

114691

18 10-6-4

24

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39153
Description: Gasket		Part Number:	D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	X			
0.300 x 0.300	+/-0.010	307 x 309	X			
1.88	+/-0.030	1.891	X			
4.281	+/-0.010	4.280	X			
6.44	+/-0.030	6.445	X			
6.00	+/-0.030	6.00	X			
6.75	+/-0.030	6.75	X			
2.00	+/-0.030	2.002	X			
4.75	+/-0.030	4.75	X			
9.50	+/-0.030	9.50	X			
14.25	+/-0.030	14.25	X			
17.75	+/-0.030	17.75	X			
26.74	+/-0.030	26.74	X			
29.23	+/-0.030	29.23	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-6-24	Date: 10/6/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	

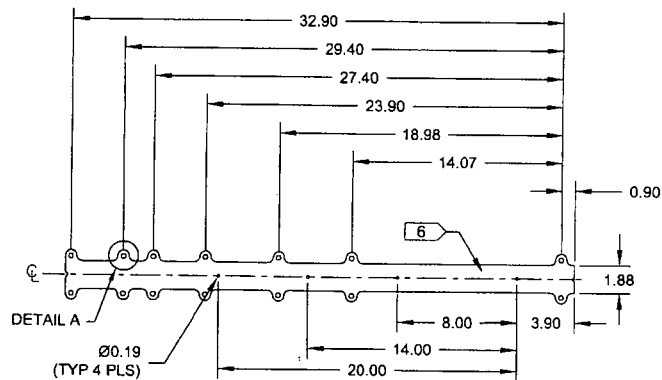
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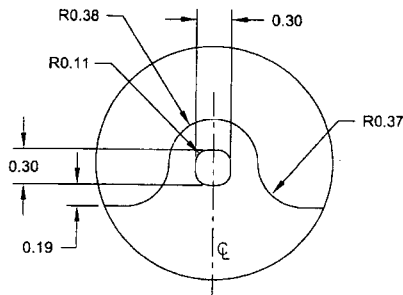
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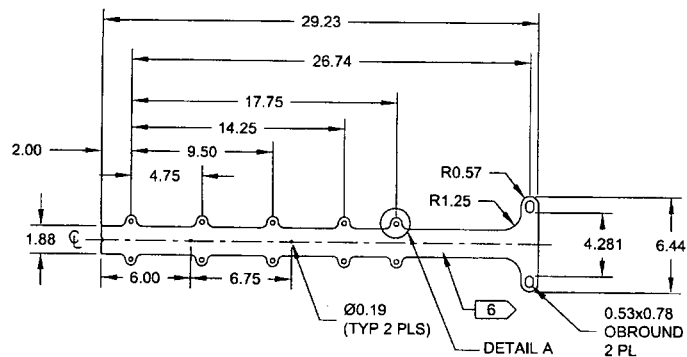
NOTE: Date & initial all entries



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59133

RELEASED
08-05-14

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "XXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

A		NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION			BY	DATE
DESIGN	PH			DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. REV. A D3794 SHEET 1 OF 1 TITLE SCALE GASKET NT	
DRAWN	PH				
CHECKED					
MFG. APPR.	DS				
APPROVED	PH				
DE APPR.	PH				
DATE	08.05.14			COPYRIGHT © 2008 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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